

Date: Monday, 11/6/2006 2:39:51 PM
 User: Kim Johnston

Process Sheet

| | | | |
|----------------------------------|---|-------------------------|---------------|
| Customer | CU-DAR001 Dart Helicopters Services | Drawing Name | : WEB |
| Job Number | 29341 | Part Number | : D2739 |
| Estimate Number | : 10498 | Drawing Number | : D2739 REV C |
| P.O. Number | : N/A | Project Number | : N/A |
| This Issue | : 11/6/2006 | Drawing Revision | : C |
| Prsht Rev. | : NC | Material | : N/A |
| First Issue | : N/A | Due Date | : 11/20/2006 |
| Previous Run | : 29316 | Qty: | 4 Um: Each |
| Written By | : <i>[Signature]</i> | | |
| Checked & Approved By | : <i>[Signature]</i> 06/11/07 | | |
| Comment | : Est Rev: C 02.11.28 Reformat KJ Est Rev: D 06-03-21 As Per Rev C JLM | | |

Additional Product

Job Number:



| | | |
|----------------|------------------------------|----------------------|
| Seq. #: | Machine Or Operation: | Description : |
|----------------|------------------------------|----------------------|

| | | |
|-----|-----------|-------------------------|
| 1.0 | D26005108 | Extrusion 'I Beam' thin |
|-----|-----------|-------------------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Extrusion 'I Beam' thin

Pick:

Qty Part Number Description Batch

1 D2600-5 Web

B24410

M.R 06/11/13

⑤

| | | |
|-----|----------------|-------------------------|
| 2.0 | LANDING GEAR 1 | LANDING GEAR RESOURCE 1 |
|-----|----------------|-------------------------|

**Comment:** LANDING GEAR RESOURCE 1

1-Cut D2600-5 to length as per Dwg D2739.

M.R 06/11/13 ④

2-Drill pilot holes in web using drilling Jig DT8162 as per Dwg D2739

M.R 06/11/13 ④

3-Use uni-bit to open holes to finish size as per Dwg D2739.

M.R 06/11/14 ④

4-Bevel Fwd ends (1" max) of extrusion and Deburr holes and ends.

M.R 06/11/14 ④

5-Deburr

M.R 06/11/14 ④

| | | |
|-----|-----|------------------------------|
| 3.0 | QC5 | INSPECT WORK TO CURRENT STEP |
|-----|-----|------------------------------|

**Comment:** INSPECT WORK TO CURRENT STEP

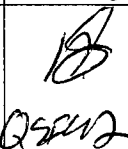
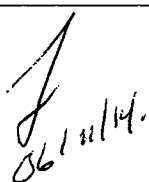


DP

6-11-20

④

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/11/2014
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|----------|------|--|--|---------------------------------|------------------|--|--|--|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| 06-11-14 | 2.0 | 1 web scrap. 1" holes drilled in .750 location (shoofles). human error |  | Destroy & Replace web. | M.R. 06/11/14 |  06/11/14 |  06/11/14 |  06/11/14 |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Monday, 11/6/2006 2:39:52 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEB

Job Number: 29341

Part Number: D2739

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M.B 06/11/14 (4)

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

DP 6-11-20 (4)

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Use a red or black lead-free paint pen to write the part number and batch number in the middle of each web.

Identify and Stock

Location: LG

DP 6-11-20 - 4

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

DP 06/11/20 (4)

Job Completion



U. 06-11-20

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

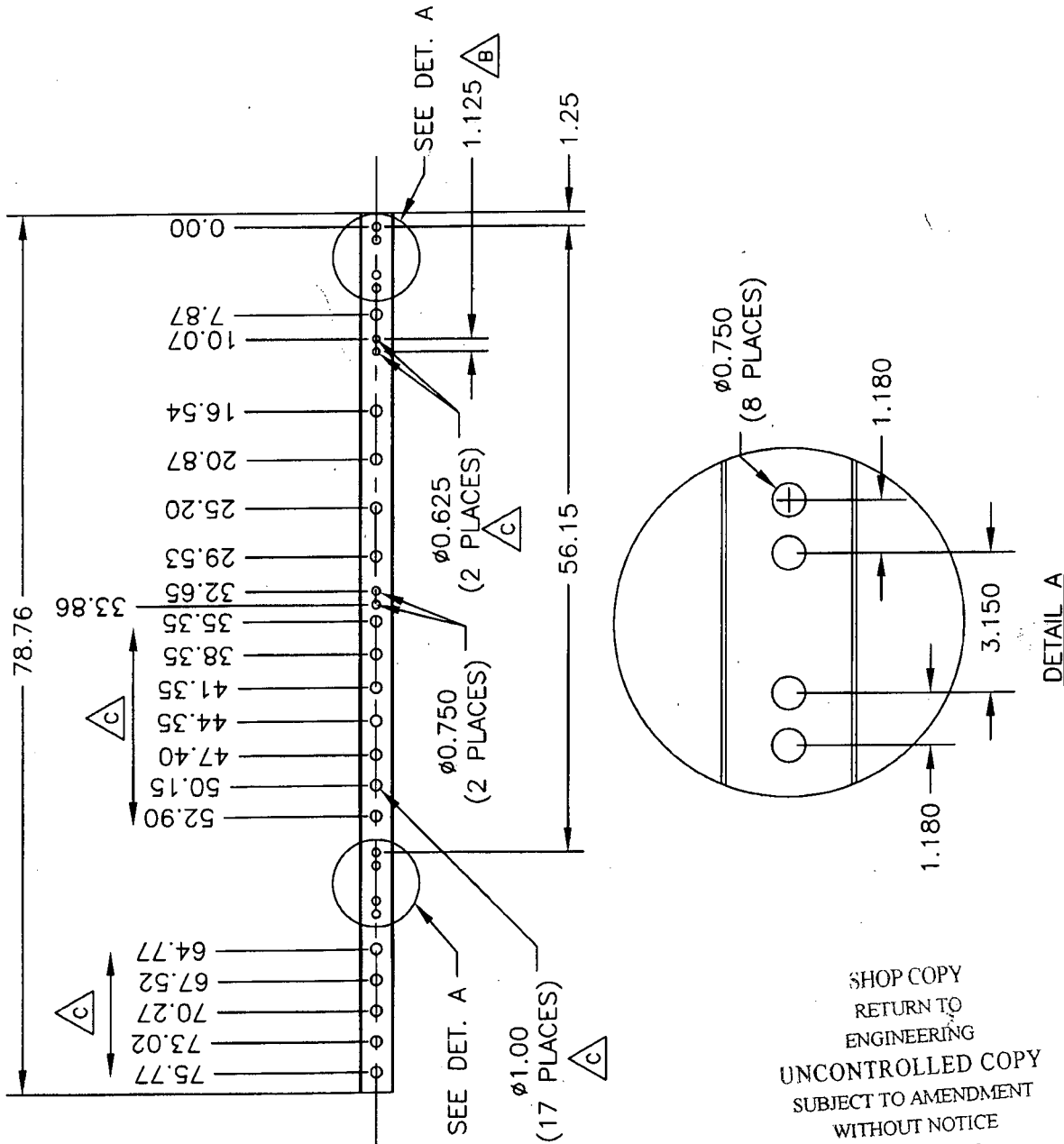
QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

DART**RELEASED**
06.01.05

| | | | |
|------------------------|-------------------------------|--|------------------------|
| DESIGN RH | DRAWN BY RH | DART AEROSPACE USA, INC. PORT HADLOCK, WA | |
| CHECKED [Signature] | APPROVED [Signature] | DRAWING NO. D2739 | REV. C SHEET 1 OF 1 |
| DATE 06.01.05 | TITLE WEB SCALE 1:15 | | |
| A | 98.04.16 | NEW ISSUE | |
| B | 98.11.18 | CHANGE HOLES FOR COMPATABILITY WITH AIRCRUISER FLOATS | |
| C | 06.01.05 | ADD/MOVE HOLES FOR COMPATABILITY W/APICAL FLOATS | |



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 29341

- D2739 WEB
- 1) MATERIAL: MAKE FROM D2600-5 EXTRUSION
2) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
3) ALL DIMENSIONS ARE IN INCHES
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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